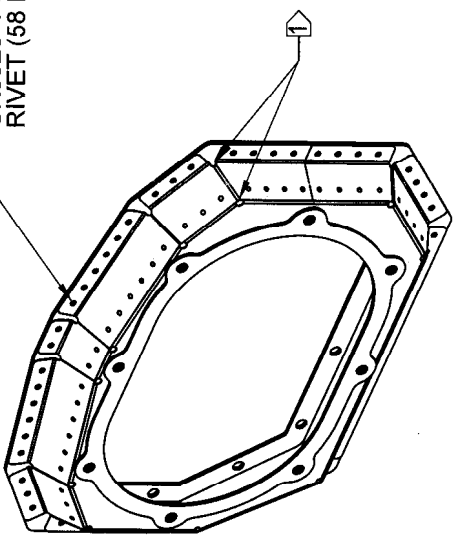


INSTALL
CR3523-4-02 OR NAS9307M-4-02
RIVET (58 PLACES)







PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

REVISION
08.03.27/MP

D3651-041 AFT BASE ASSEMBLY

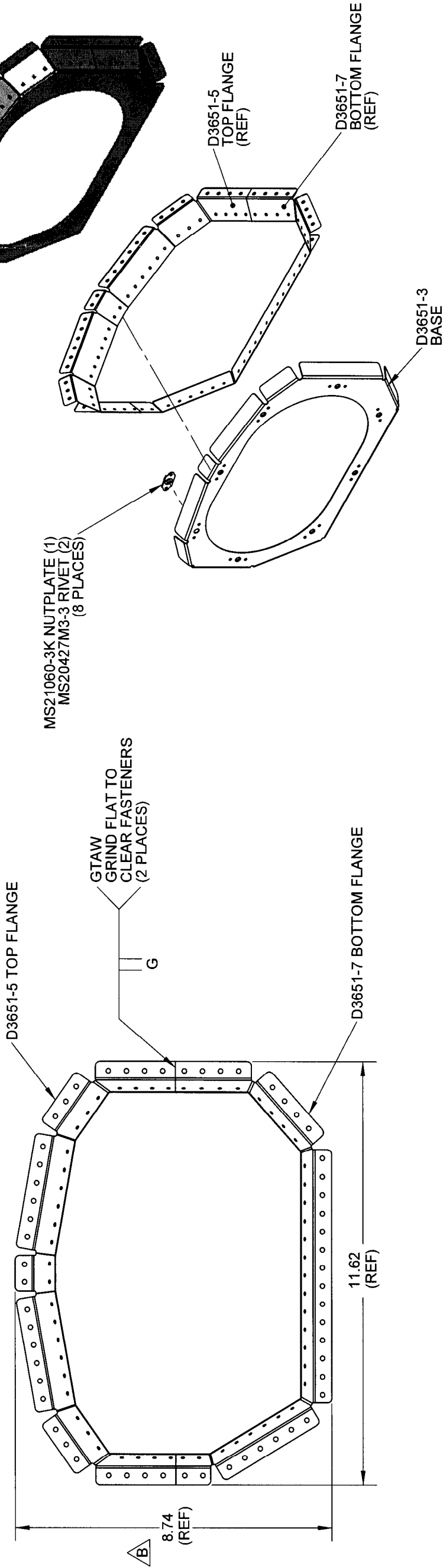
- D3651-041 NOTES:
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504		RF	08.01.07
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3651	SHEET 1 OF 9	
APPROVED		TITLE	SCALE	
DE APPR.		AFT BASE ASSEMBLY	1:4	
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8 7 6 5 4 3 2 1

D C B A

TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NA9307M-4-02
RIVETS (57)



QTY	PART NUMBER	DESCRIPTION
-043		
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

D3651-043 FLANGE WELDMENT

- D3651-043 NOTES:**
- WELD PER QSI 004
 - FINISH: NONE
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - IDENTIFICATION: NONE
 - WEIGHT: 0.76 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3651**

REV. **B**

SHEET 2 OF 9

TITLE **AFT BASE ASSEMBLY**

SCALE **1:3**

DATE **08.01.07**

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8 7 6 5 4 3 2 1

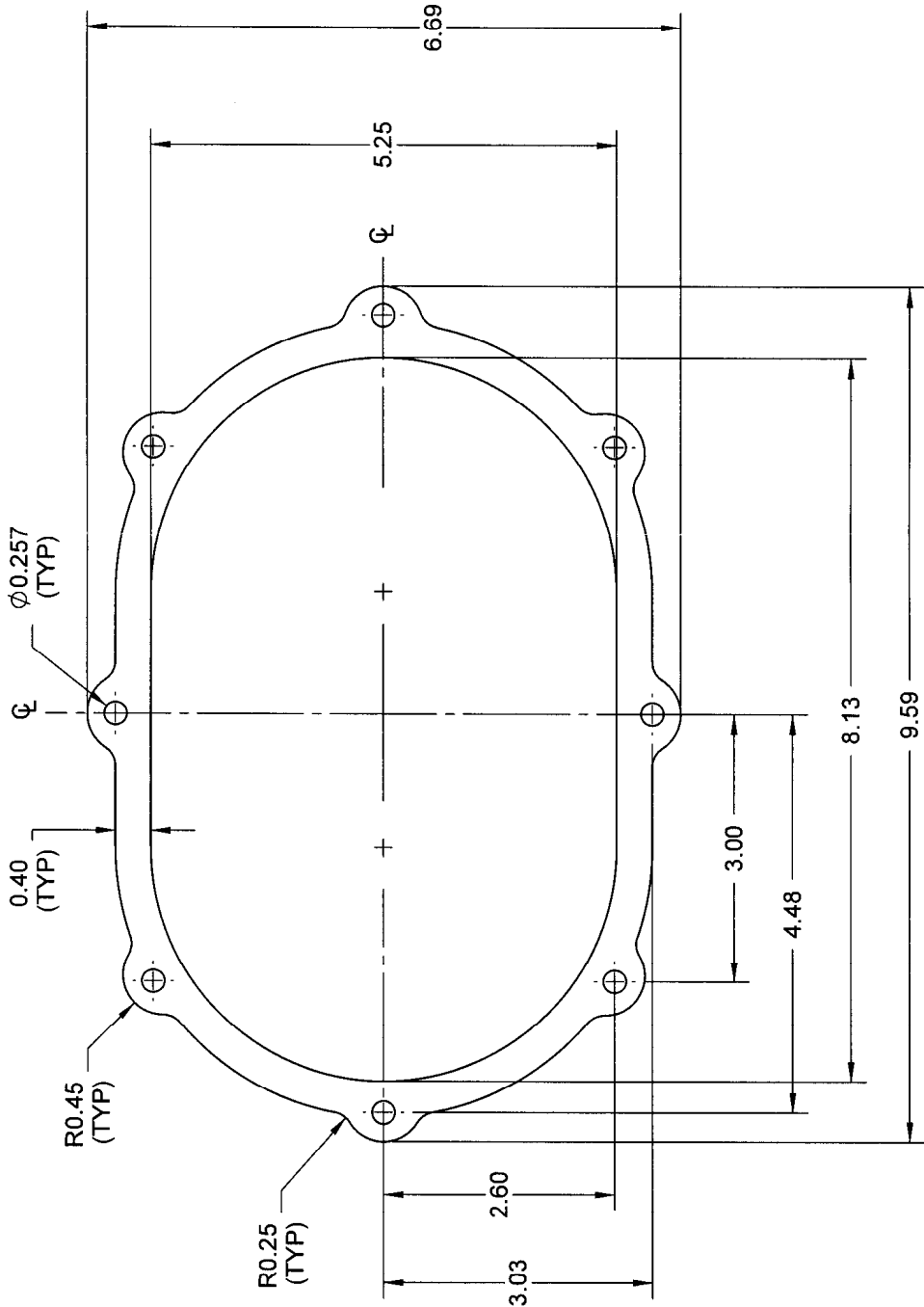
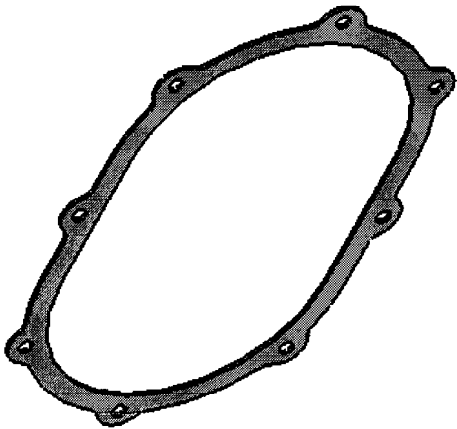
8 7 6 5 4 3 2 1

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C

B

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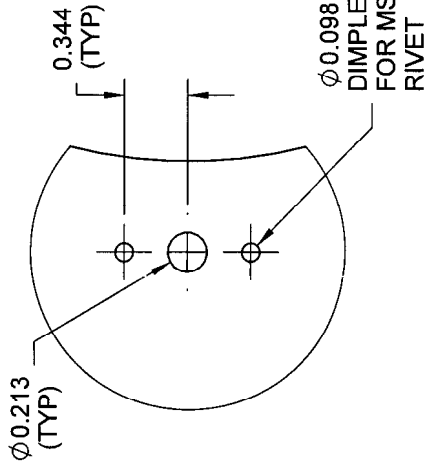
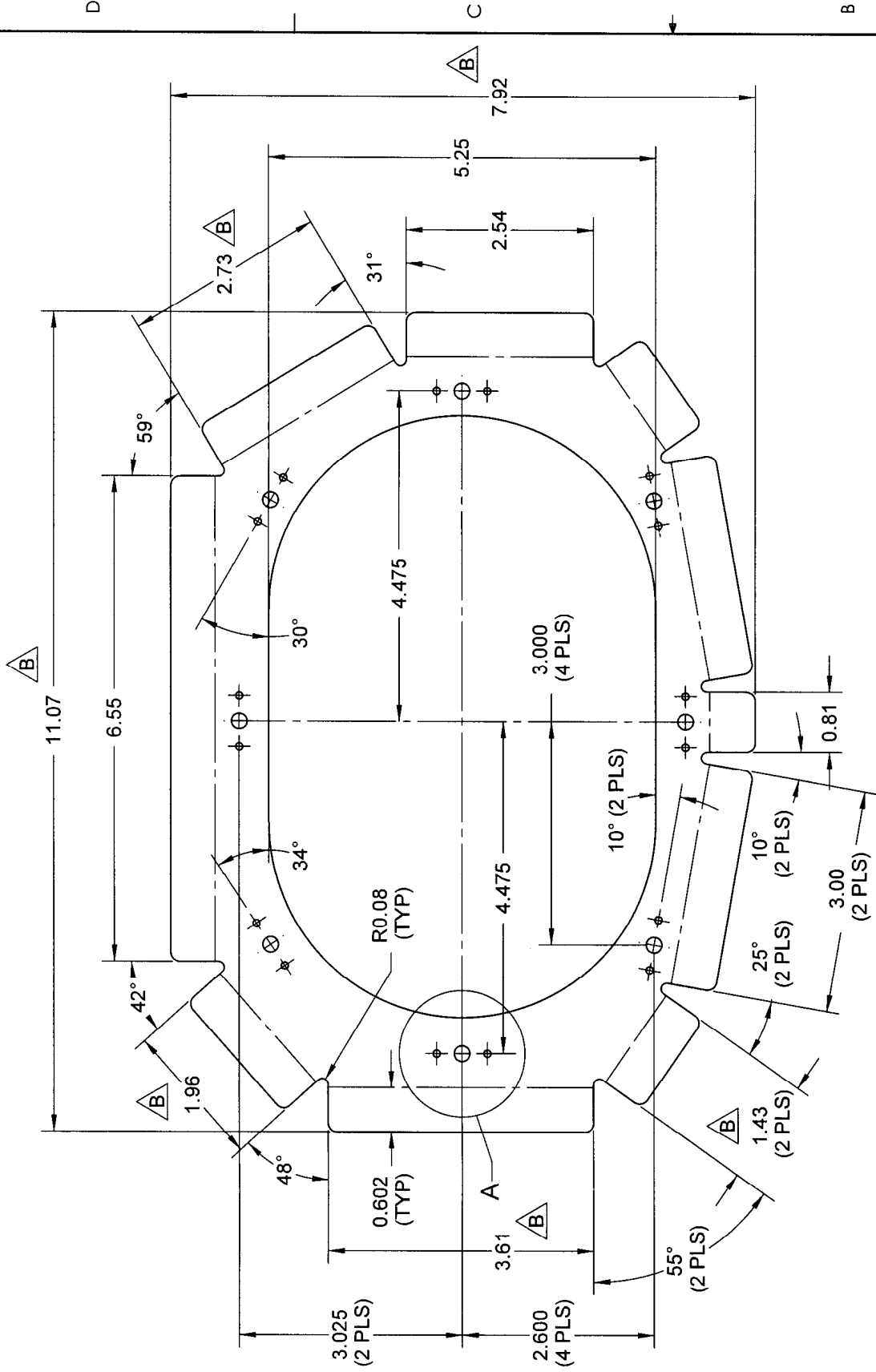
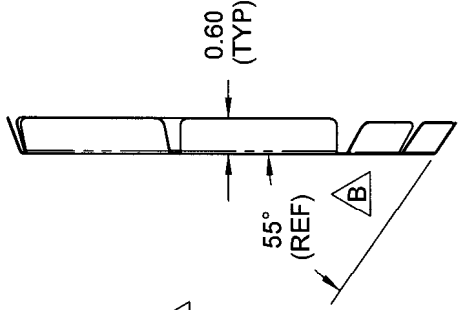
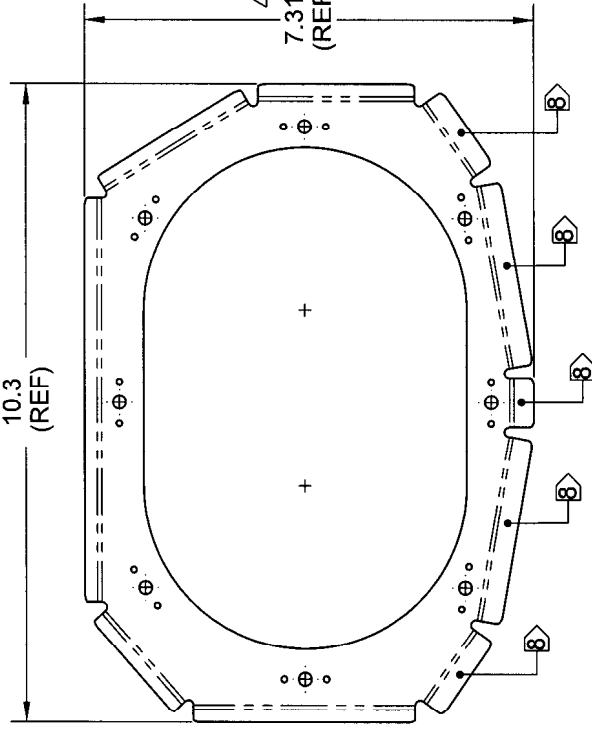


D3651-1 GASKET

- NOTES:
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) PART IS SYMMETRIC ABOUT \varnothing
 - 8) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD
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CHECKED	RF	DRAWING NO. REV. B
MFG. APPR.	RF	D3651 SHEET 3 OF 9
APPROVED	RF	TITLE SCALE
DE APPR.	RF	AFT BASE ASSEMBLY 1:2
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8 7 6 5 4 3 2 1



D3651-3F FLAT PATTERN

D3651-3 BASE (MAKE FROM D3651-3F FLAT PATTERN)

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs
 - 8) BEND TO 55° WHERE INDICATED

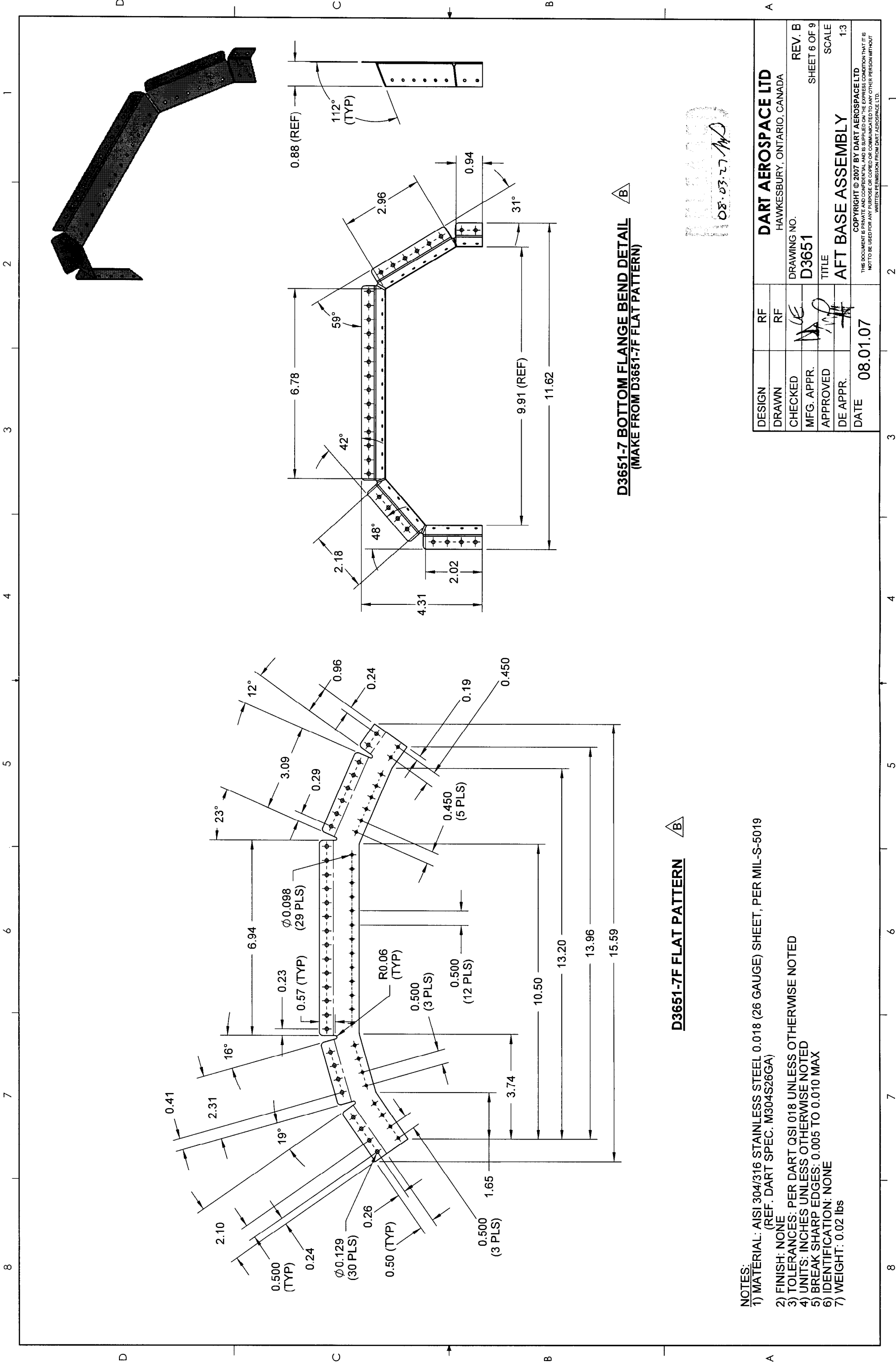
Ø 0.098 (TYP)
DIMPLE HOLES
FOR MS20427M3
RIVET

DETAIL A

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	ME	DRAWING NO. REV. B
MFG. APPR.	ME	D3651 SHEET 4 OF 9
APPROVED	ME	TITLE SCALE
DE APPR.	ME	AFT BASE ASSEMBLY 1:2
DATE	08.01.07	

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08.03.27 MD



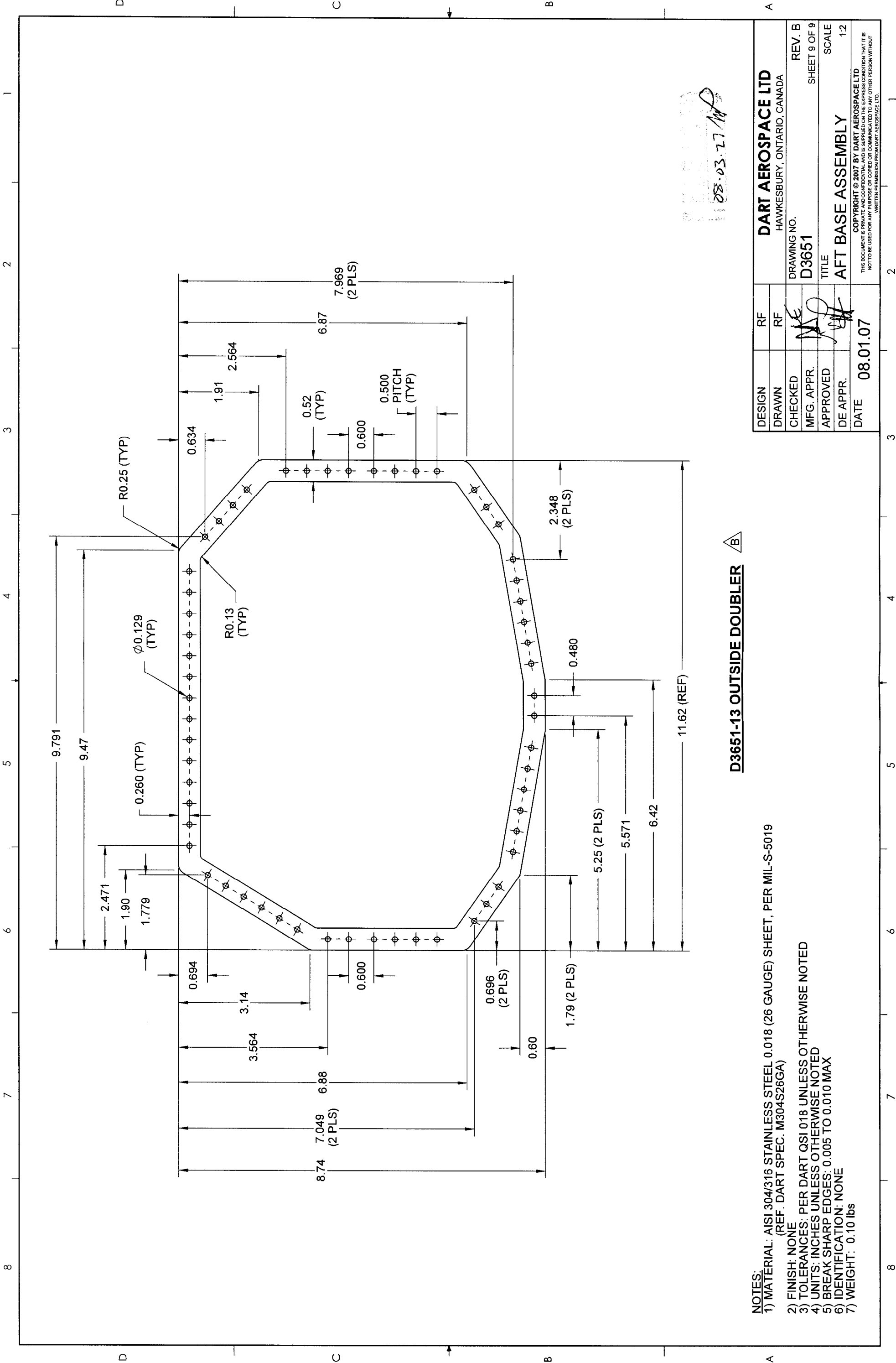
D3651-7 BOTTOM FLANGE BEND DETAIL B
(MAKE FROM D3651-7F FLAT PATTERN)

D3651-7F FLAT PATTERN B

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	AFT BASE ASSEMBLY
DATE	08.01.07	
		SCALE 1:3
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DRAWING NO. **D3651**
REV. B
SHEET 6 OF 9



D3651-13 OUTSIDE DOUBLER

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. REV. B
MFG. APPR.	RF	D3651 SHEET 9 OF 9
APPROVED	RF	TITLE SCALE
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088-03-27 MP